

May 10, 2010 12:39:26 PM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 10/05/2010    **Start Qty:** 4.00

**Cust Item ID:**

**Required Date:** 14/05/2010      **Req'd Qty:** 4.00



**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date: 11-5-10

**Tooling:**

**Date:**

Run Start



**QC:**

Date:

**SPC (Y/N):**

**Date:**

**Stop**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58543

May 10, 2010 12:39:26 PM



Page 2

Item ID: D3136-043

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Thermoform Thermoforming Machine	THERMOFORMING MACHINE  Memo 1-Thermoform as per Dwg D3136 and Folio FTA002□Dwg Rev. <u>E</u> □Folio Rev. <u>C</u> □2- Engrave Part # and Batch # , and affix labels □ (D3136-3)	0.00  0.00							<u>BB</u> 10/05/17 X6
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00							<u>BB</u> 10/05/17 X6
150  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							8 10/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


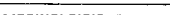



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

May 10, 2010 12:39:26 PM

<b>Item ID:</b>	D3136-043	<b>Accept</b>		<b>Setup</b>	<b>Start</b>	
<b>Revision ID:</b>						
<b>Item Name:</b>	Window Assembly				<b>Stop</b>	
<b>Start Date:</b>	10/05/2010	<b>Start Qty:</b> 4.00		<b>Cust Item ID:</b>		
<b>Required Date:</b>	14/05/2010	<b>Req'd Qty:</b> 4.00		<b>Customer:</b>		
<b>Reference:</b>						

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 58543**

May 10, 2010 12:39:26 PM



Page 4

Item ID: D3136-043

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/05/21

U 10.05.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

May 10, 2010 12:39:30 PM

Page 1

Work Order ID: 58543

Parent Item: D3136-043

Parent Item Name: Window Assembly

Comments: IPP Rev:A 04.02.04 New issue KJ/DS

IPP Rev.B 07.05.29 Thermoform in-house DL


IPP rev C 07.09.28 Rev E dwg EC verified by:DD

Start Date: 10/05/2010

Required Date: 14/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D3108-9		Manufactured	No			100	Each	732.0000	2			
												
Decal												

Location

Loc Qty

Loc Code

ST036

732

34554

232

46546

500

MACRLICS.125

Purchased

No

170

sf

14.4000

3.9



1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT

14.4

113204

4

113861

10.4

114673

30.

10-5-13

33  
10/05/17

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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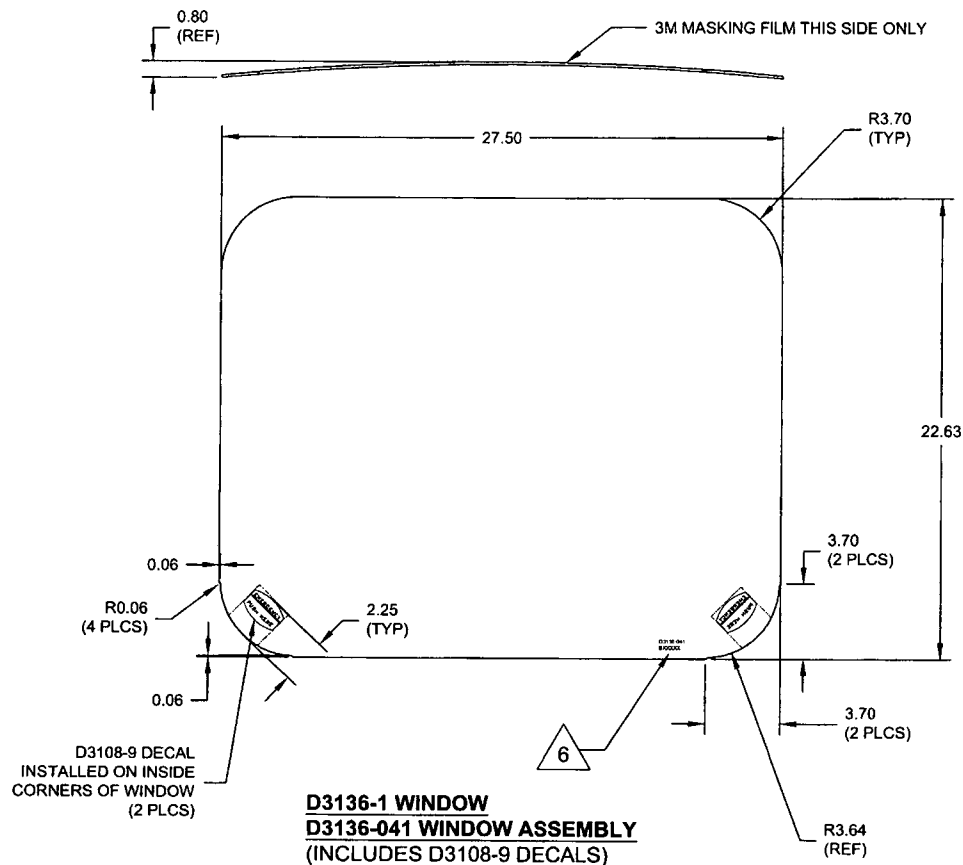
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

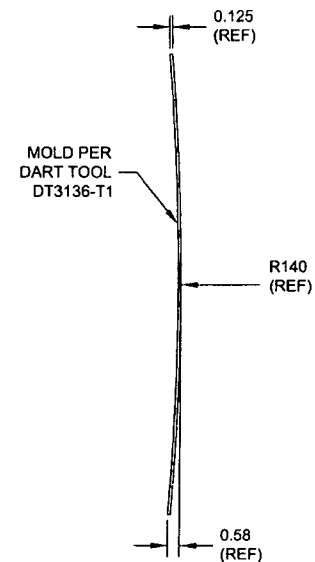
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO REVISIONS  
WITHOUT NOTICE  
WORK ORDER NO. 58543

*10-5-10*

**RELEASED**  
07.09.10

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3136 TITLE WINDOW ASSEMBLY SCALE 1:6 REV. E SHEET 1 OF 2			
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